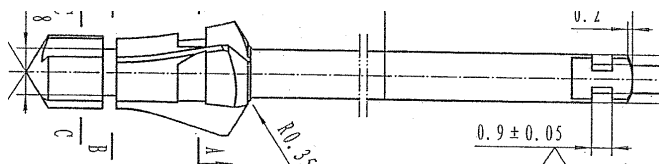








Dental Countersink Ø3.5/4.8 Z3

A26-560

The dental countersink is ground in one setup clamped on the 2.35 shank and additionally supported in a V-shaped steadyrest. For automatic loading the steadyrest can be automatic. The 2 radius-shaped clearances are ground based on a DXF-file. Grinding time for O.D. is low due to usage of fullform wheel. Preorientation of the blank is given through loading without probing.



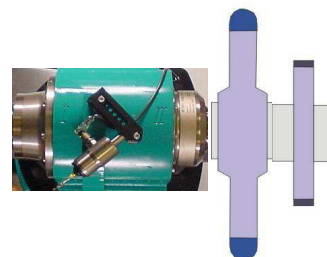
1. Cycletime for Production

Workpiece: Ø3.5/4.8 mm, Z 3, Length 7.6 mm, Rad.Step R10.8 Material HSS			
Operations	 Rad.Step 2	 Rad.Step 1	 Flute
Feed [mm/Min]	200	300	120
Power [kW]	1	1	1
Cutting speed [m/s]	32	32	32
Used wheels	 1	 1	 2
Grinding time [s]	18	14	35
Total cycle time	1 Min 6		

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø175 B91
2	1A1 Ø75 B76



1 2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Control: Fanuc 31iA5

Accessories: Steadyrest at shank and tip

Responsible engineer: PSI, 26.4.12

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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